

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019707**Date Inspected:** 28-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** SHANGHAI CHINA**CWI Name:** Mr. An Qing Xing.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG TRIAL ASSEMBLY**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

Lift 11W

Shielded Metal Arc (SMAW) welding of Weld Joint OBW11C-007(11DW+11EW,SP-SP,CW Side), And Critical Welding Repair Report(CWR)B-CWR2272(R2),Welder is identified as 040611; ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG071A-044(11DW+11EW,BP-SP,CW Side, Out Side), And Critical Welding Repair Report(CWR)B-CWR2301,Welder is identified as 040611; ZPMC Quality Control (QC) is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG071A-044(11DW+11EW,BP-SP,CW Side, Inside), And Critical Welding Repair Report(CWR)B-CWR2301,Welder is identified as 046704; ZPMC Quality Control (QC)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07526

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as OBG 11E & 11W welds. The weld designations reviewed are as follows.

1. SSD19-PP96-109~114
2. CSD9-PP108-145~149
3. SSD11A-PP99-003,004

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07529

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as OBG 11EW PP108 welds. The weld designations reviewed are as follows.

1. CSD9-PP108-145,146,147,148,149

Note:-Incident Report Generated for the Weld joint CSD9-PP108-146, and joint has Rejected .

-Two (2) longitudinal indication 10mm&15mm in length found Toe of the Fillet weld identified as CSD9-PP108-146 .

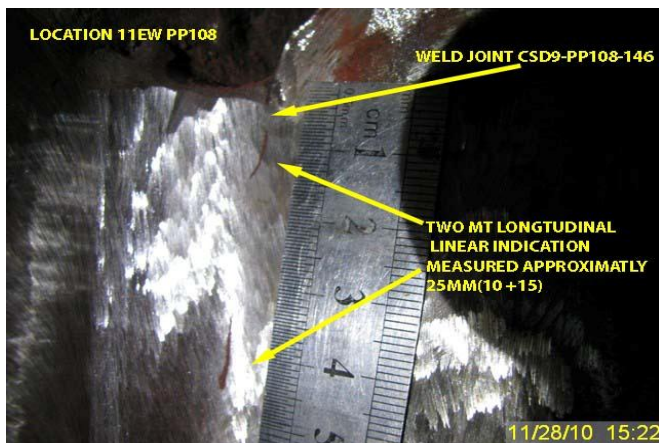
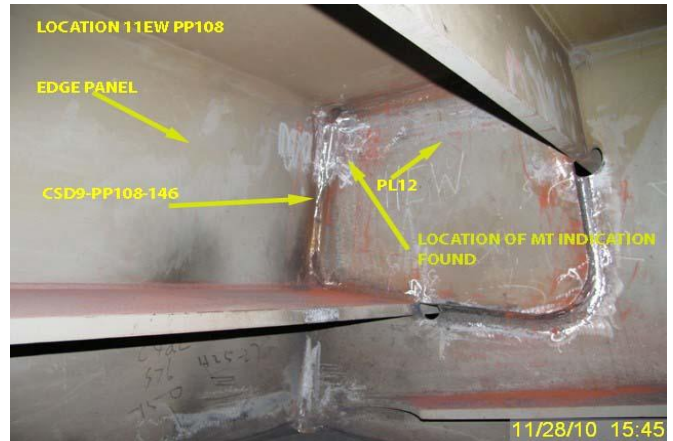
-The weld is a Fillet weld (CSD9-PP108-146), joining the Floor beam (FB9B) to suspender bracket retro plate (PL12).

For further information, please see the attached pictures below.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By: Tharikoppada,Reddy

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer